Thursday, 19/03/2009 4:30:39 PM Date: User: Julie Dawson Customer : CU-DAR001 Dart Helicopters Services Job Number : 46609 **Estimate Number** : 10517 P.O. Number : 19/03/2009 S.O. No. : This Issue Prsht Rev. : NC First Issue : // Type : 42174 **Previous Run** Written By Checked & Approved By Comment : Est:B **Additional Product** Job Number: Seq. #: 1.0 M6061T6H1000 Comment: Qty.:

Process Sheet

Drawing Name

: BUSHING

Part Number

: D28061 . D2806 REV A

Drawing Number Project Number

: N/A

Drawing Revision

: A

Material

Due Date : 30/03/2009 Qty:

40 Um: Each

05.03.11

Part now turned KJ/JLM

Est Rev:C Now on Doosan Lathe JLM Verified By:EC

: MACHINED PARTS



Machine Or Operation:

Description:

6061-T6 HexBar 1.00



Total:

3.8472 f(s)

6061-T6 Hex Bar 1.0"

Material: 6061-T6 (QQ-A-200/8 or QQ-A-250/11) 1.00" Hex Bar

(M6061T6H1.000)

Batch:

2.0

DOOSAN LATHE

DOOSAN LATHE

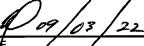


Comment: Doosan Lathe

1- Turn as per Folio FA105 Rev: 4 & Dwg D2806 Rev:

2-Deburr per dwg D2806

INSPECT PARTS AS THEY COME OFF MACHIN



3.0

QC2

Comment: INSPECT PARTS AS THEY COME OFF MACHINE

4.0

QC8

SECOND CHECK



Comment: SECOND CHECK



5.0

HAND FINISHING1

HAND FINISHING RESOURCE #1



Comment: HAND FINISHING RESOURCE #1

Acid etch and Alodine as per QSI 005 4.1

09-03-



Dart Aerospace Ltd

W/O:			WORK ORDER CHANGES							
DATE	STEP	PF	ROCEDURE CHANGE	В	Ву	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector	
Part No	:	PAR #:	Fault Category:	NCR:	Yes	No DQ	A:	_ Date: _		
	Resoluti	on:	Disposition:	QA: N	/C CI	osed:		Date: _		

NCR:		WORK ORDER NON-CONFORMANCE (NCR)								
		Description of NC		Corrective Action Section B						
DATE	STEP	Section A	Initial Chief Eng	Action Description Chief Eng	Sign & Date	Verification Section C	Approval Chief Eng	Approval QC inspector		

NOTE: Date & initial all entries

Date: Thursday, 19/03/2009 4:30:39 PM User: Julie Dawson **Process Sheet** Customer: CU-DAR001 Dart Helicopters Services **Drawing Name: BUSHING** Job Number: 46609 Part Number: D28061 Job Number: Seq. #: **Machine Or Operation:** Description: INSPECT POWDER COAT/CHEMICAL CONVERSION 6.0 QC3 **Comment: INSPECT ALODINE** 7.0 PACKAGING 1 PACKAGING RESOURCE #1 Comment: PACKAGING RESOURCE #1 Identify and Stock Location: 8.0 QC21 FINAL INSPECTION/W/O RELEASE Comment: FINAL INSPECTION/W/O RELEASE Job Completion

Dart Aerospace Ltd	Dart	Aeros	pace	Ltd
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W/O:			WO	RK ORDER CHANG	ES				
DATE STEP		PR	Ву	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector		
			•						
Part No	•	PAR #:	Fault Categ	ory:	NCR: Yes	No DQ	A :	Date: _	
	Res	solution:	Disposition	:	_ QA: N/C (Closed:		Date: _	
NCR:			WORK ORDE	R NON-CONFORMA	NCE (NC	R)			
DATE	CTED	Description of NC		on B	Verific	cation	Approval	Approval	
DATE	STEP	Section A	Initial Chief Eng	Action Description Chief Eng	Sign Date	& Secti	Section C	Chief Eng	QC Inspector
									i

NOTE: Date & initial all entries

DART AEROSPACE LTD	Work Order:	16008
Description: Bushing	Part Number:	D2806-1
Inspection Dwg: D2806 Rev: A		Page 1 of 1

	FIRS ⁻	T ARTICLE II	NSPECTI	ON CHE	ECKLIST		
	X	First Arti	cle	Prot	otype		
Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Cor	mments
1.000	+/-0.010	1.00					
1.155	+/-0.010	1.140				STK	MAT'L
0.250	+/-0.010	-250	/				
0.063 x 45°	+/-0.010	.063×45	P				
0.080 x 45°	+/-0.010	075×45	· /				
0.495	+0.000/-0.005	.492	-				
0.750	+0.000/-0.005	75.746	-				
Ø0.257	+0.005/-0.000	-259	~				
0.094	+/-0.010	.690					
Measured by:	D 1 1	Audited by:	J.F.		Prototype Ap	proval:	N/A
Data: /	10 /2 /27	Data	-1621	/		Datas	ALIA

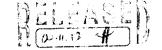
Measured by:		Audited by: J.F.	Prototype Approval:	N/A
Date: 09 /03/	22	Date: 09/03/23	Date:	N/A

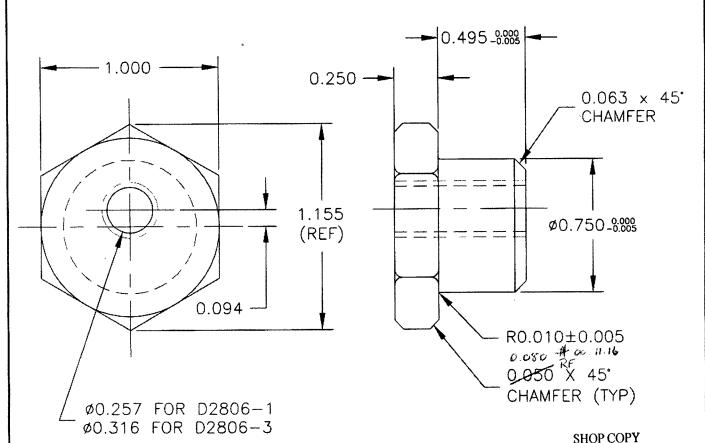
Rev	Date	Change	Revised by	Approved
Α	04.02.25	New Issue	KJ/RF	
В	08.01.16	0.094 dimension added	KJ/EC/DD	178
			()	





	DESIGN	DRAWN BY		OSPACE LTD ONTARIO, CANADA
1	CHECKED	APPROVED	DRAWING NO.	REV. A
,	P	A	D2806	SHEET 1 OF 1
	DATE		TITLE	SCALE
	00.11.08		BUSHING	2:1
	Α	00.11.08	NEW ISSUE	





D2806-1 (DRILL Ø0.257 HOLE) D2806-3 (DRILL Ø0.316 HOLE)

RETURN TO ENGINEERING UNCONTROLLED COPY SUBJECT TO AMENDMENT WITHOUT NOTICE

MATERIAL: 6061-T6 (QQ-A-200/8) OR (QQ-A-250/11) OR (QQ-A-225/8) FINISH: ACID ETCH AND ALODINE PER DART QSI 005 4.1 BREAK ALL UNMARKED SHARP EDGES 0.010 TO 0.020

TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED

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